

4715.0820 SOLDERED OR BRAZED JOINTS.

Joints with copper tube with solder joint fittings must be soldered or brazed. Copper tubing must be reamed out to the full interior tubing dimension before soldered or brazed joints are made. Surfaces to be soldered or brazed must be thoroughly cleaned. Joints to be soldered must be properly fluxed with noncorrosive paste or liquid type flux complying with ASTM Standard B813-00. Solder and flux used in potable water systems must not contain more than 0.2 percent lead. Solder used for joints must have a nominal composition of 50 percent tin and 50 percent lead, 95 percent tin and five percent antimony, or 96 percent tin and four percent silver, conforming to ASTM Standard Specification for soft solder metal B32-94, except that 50 percent tin and 50 percent lead solder must not be used in potable water systems. Alternative solders may be used if specifically approved by the administrative authority after review of testing laboratory or listing agency documentation. Brazing must be done using a brazing filler metal which is manufactured for the particular application, and using methods specified by the filler metal manufacturer.

Statutory Authority: *MS s 16B.59 to 16B.73; 326.37 to 326.45; 326B.101 to 326B.151; 326B.43 to 326B.49*

History: *11 SR 1405; 15 SR 76; 28 SR 146; L 2007 c 140 art 4 s 61; art 6 s 15; art 13 s 4; L 2008 c 337 s 64*

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